

Work Order ID 53007

October 21, 2009 7:58:12 AM



Page 1

Item ID: D3822-7KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Vertical Tunnel, Lower-Grey

Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: BL

Date: 09-10-21

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3822

C

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB
09/10/27
X2

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA029 using tool DT9896
Dwg Rev: C
Folio Rev: _____

BB
09/10/27
X2

Work Order ID 53007

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Page 2

Item ID: D3822-7KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Vertical Tunnel, Lower-Grey

Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req. a Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB
09/10/27
X2

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

BB
09/10/27
X2

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

BB
09/10/28
X2

Work Order ID 53007

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Page 3

Item ID:	D3822-7KGY	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Vertical Tunnel, Lower-Grey					
Start Date:	21/10/2009	Start Qty:	2.00	Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Complete FAI document	0.00							BB 09/10/28 X2
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00		2) 8 09/10/07		X2	f		
170 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							Peg/10/30 (2)

Work Order ID 53007

October 21, 2009 7:58:12 AM

Page 4



Item ID: D3822-7KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Vertical Tunnel, Lower-Grey

Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/10/30 *[Signature]*
MF
09-10-30

Picklist Print

October 21, 2009 7:58:17 AM

Page 1

Work Order ID: 53007

Parent Item: D3822-7KGYRevC

Parent Item Name: Vertical Tunnel, Lower-Grey

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	702.5028	3.5218			



Kydex steel grey

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111807

702.5028

702.5028

Pl 09/10/27 (x2)

DART AEROSPACE LTD		Work Order:	53007
Description: Vertical Tunnel, Lower		Part Number:	D3822-7KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	/			
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching	/			

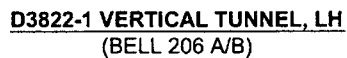
Measured by: BB	Date: 09/10/28
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20 - 0.15	Min	.18	✓			
0.060	Min	.079	✓			

Measured by: BB	Date: 09/10/28
Audited by: Jhe	Date: 09/10/28
Prototype Approval: N/A	Date: N/A

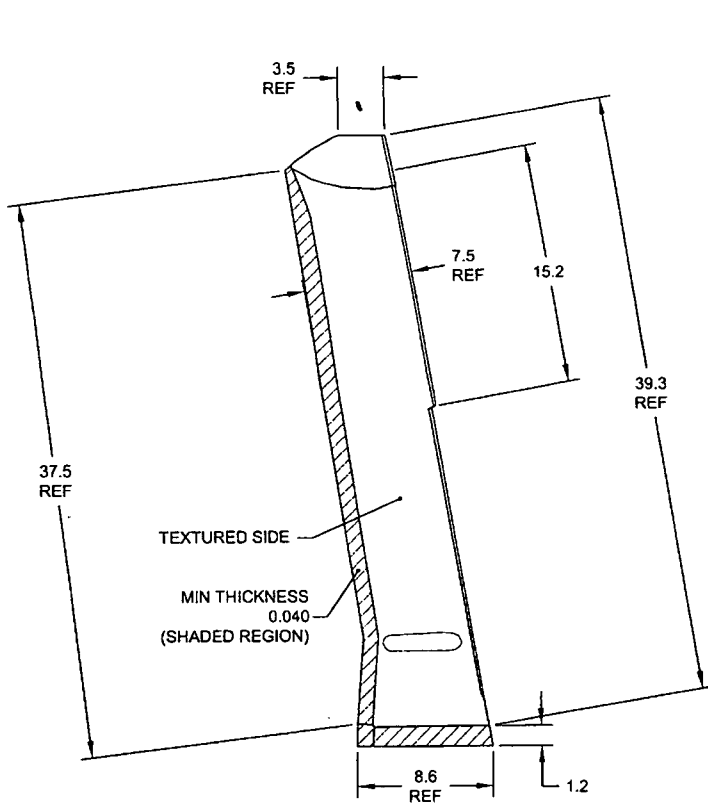
Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	



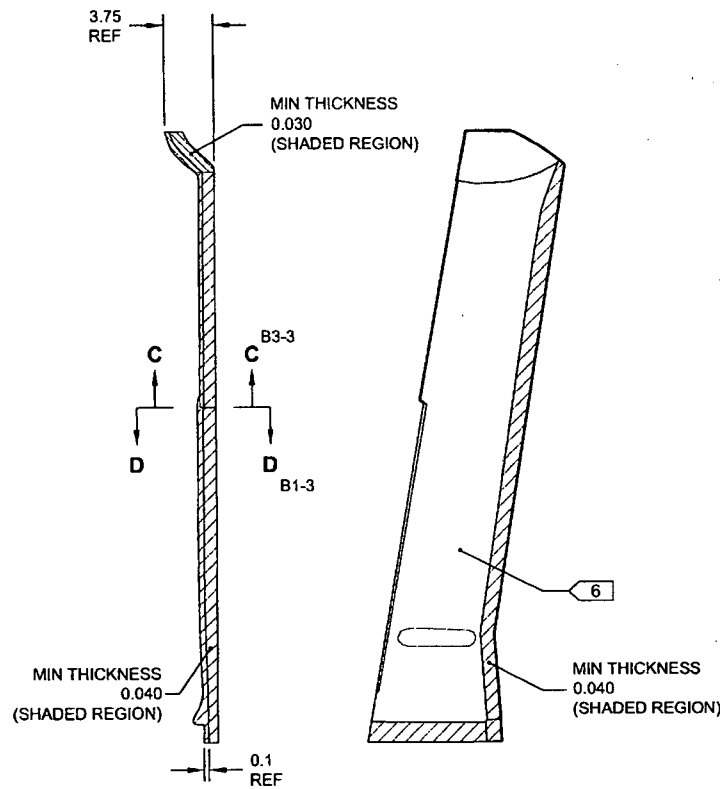
- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

C	ADD STEEL GRAY COLOUR OPTION. ADD IVORY P/N'S D3822-11-2/3-51-7(KIV) AND ADD STEEL GRAY P/N'S D3822-11-2/3-51-7(KGY) (ZN A5-1, A5-2, A5-4, A5-5, A5-6)		PH	09.05.05
B	37.8 HAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C6-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT		PH	09.02.09
A	NEW ISSUE		PH	08.09.24
REV.	DESCRIPTION		BY	DATE
DESIGN	AL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3822 TITLE VERTICAL TUNNEL (BELL 206 A/B) COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
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APPROVED				
DE APPR.		REV. C SHEET 1 OF 1 SCALE NT		
DATE	09.05.05			

RELEASE
09/03/12 MP



D3822-2 VERTICAL TUNNEL, RH
(BELL 206 A/B)



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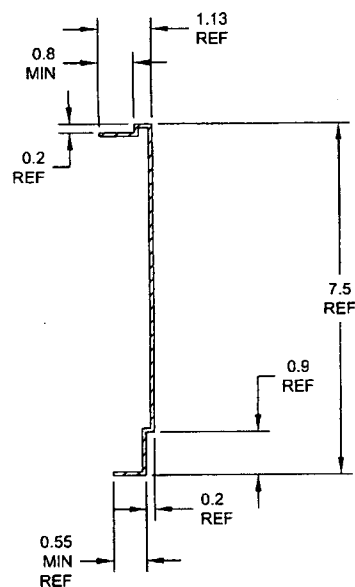
- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9074 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED



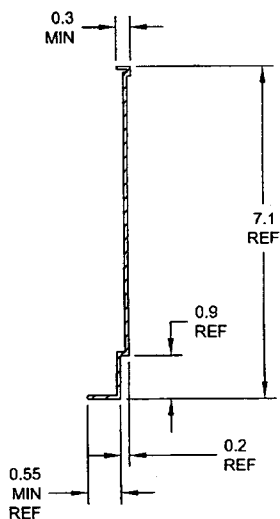
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D3822-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

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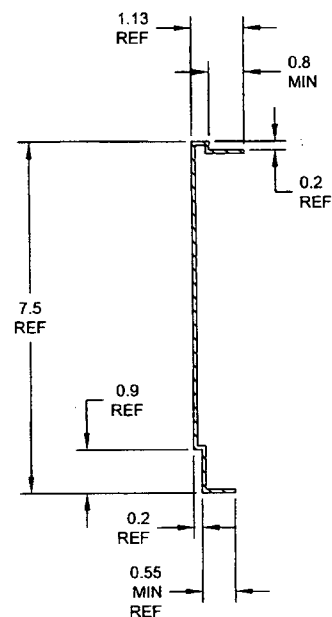
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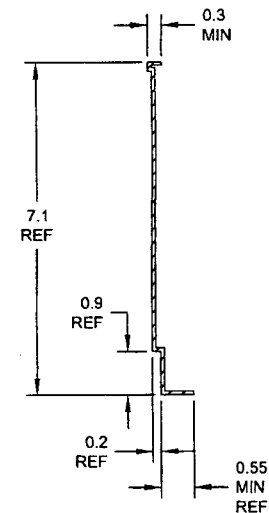
SECTION A-A C6-1



SECTION B-B C6-1



SECTION C-C C4-2

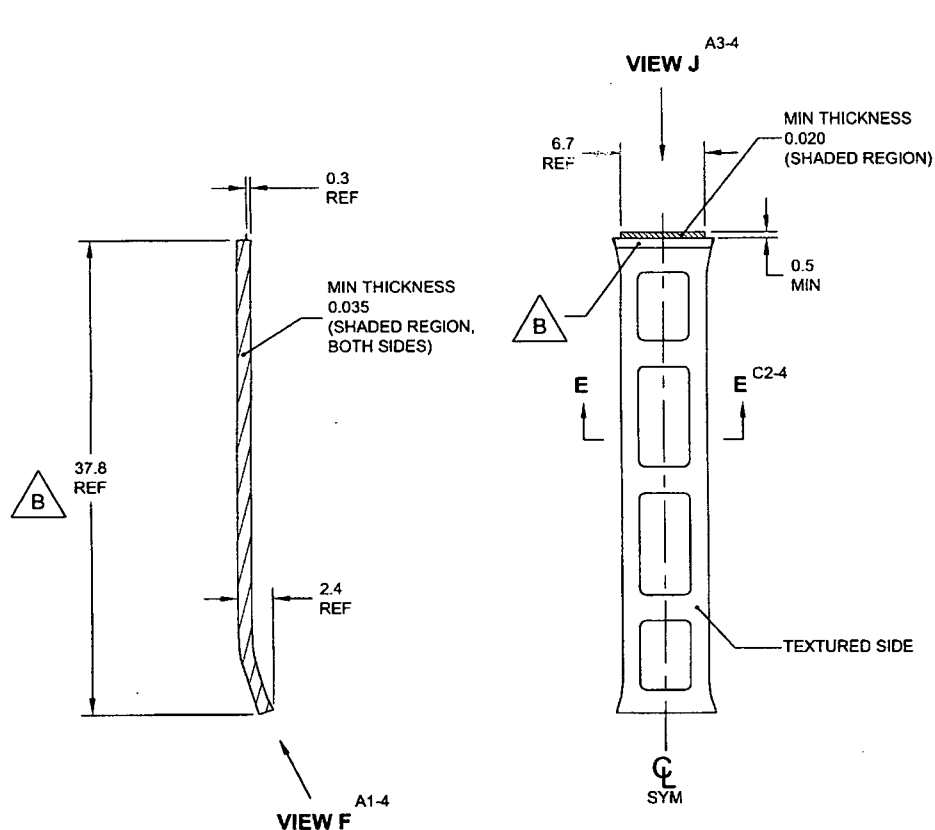


SECTION D-D C4-2

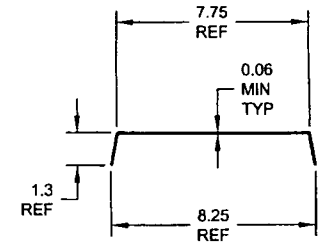
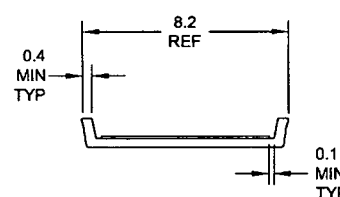
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D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

C
C

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

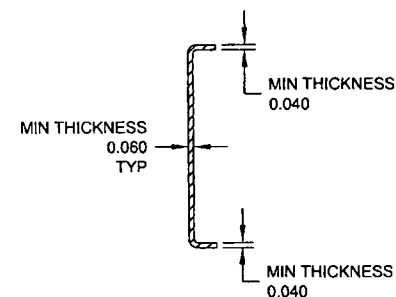
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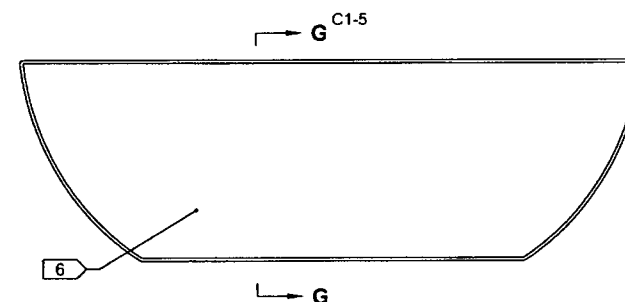
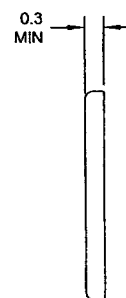
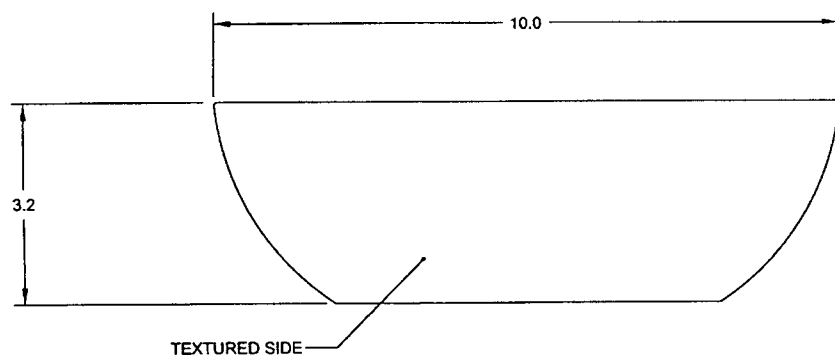
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SECTION G-G C2-5



D3822-5 VERTICAL TUNNEL, TOP
(BELL 206 A/B)

RELEASED
9/25/02 M

NOTES:

- 1) MATERIAL: SEE TABLE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.12 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9078 PER DART QSI 022

C
C

PART NUMBER	DESCRIPTION
D3822-5KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-5KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

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0.040MIN THICKNESS
0.0400.20
0.15
2.0
0.4
REF
0.3
REF17.00
MIN

TEXTURED SIDE

H^{B1-6}SECTION H-H^{B3-6}**D3822-7 VERTICAL TUNNEL, LOWER**
(BELL 206 A/B)RELEASED
09/05/22

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

C

C

PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

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APPROVED	PA	TITLE SCALE
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